

52

DART AEROSPACE	Work Order:	22027
Description: Mounting Bracket	Part Number:	D2581
<i>04.06.25</i> <i>04.06.25</i>		
Drawing: D2581 Rev. A1	Qty:	52 51

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	<i>JA</i>	04.12.08	52
2	PURCHASING	Issue P/O: <i>rev 9169</i> Laser cut as per Dwg D2581 Material: 304/316 SS 0.125" thick Material release note required	<i>LL</i>	04.12.09	52
3	RECEIVING	Receive and Inspect for transit damage Ensure material release note attached	<i>CD</i>	05/01/05	53
4	QC	Inspect Level 6	<i>2</i>	05.02.02	53
5	METAL	Deburr	<i>2</i>	05.02.07	53
6	METAL	Form as per Dwg D2581 using CNC Brake	<i>2</i>	05.02.14	51
7	QC	Inspect Level 5	<i>JA</i>	05/02/14	51
8	STORES	Identify and Stock	<i>JA</i>	05/02/14	51
9	EXPEDITING	Close W/O Cost / Part: <i>4.77</i> <i>5 ac 05/02/17</i> <i>(51)</i>	<i>JA</i>	05.02.28	51

Rev	Date	Change	Revised By	Approved
B	98.01.14	Add Inspection Level and Dwg Ref	BW	
C	99.06.29	Re-format	DM	
D	01.07.17	Added info to step 2	SM	<i>EC</i>

RELEASED

EC 01.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/02/14	6	2 bottom dimensions no good (Too wide) vertical dimensions over kept & under measurements required.		destroy & scrap First time doing.	 05-02-14	 05-02-14	 05-02-14	 05-02-14

Part No: D2581 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:
 Date: 05/02/14

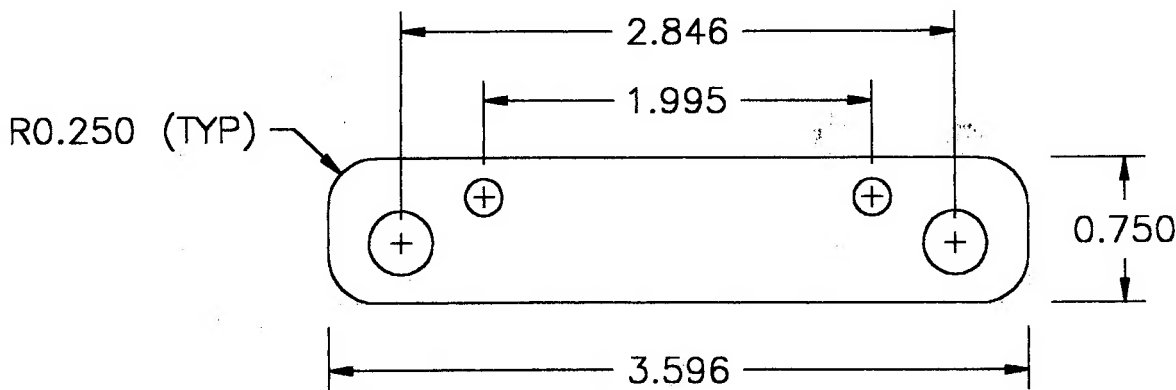
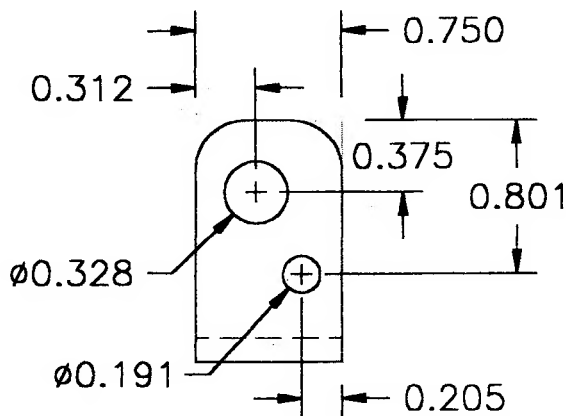
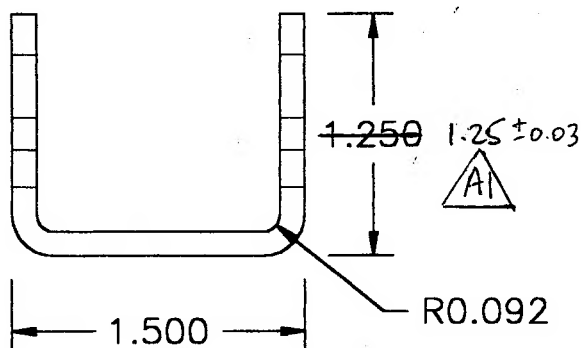
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN MIKE M	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>M. M.</i>	DRAWING NO. D2581	REV. A SHEET 1 OF 1
DATE 96.06.27		TITLE MOUNTING BRACKET	SCALE 1:1
AI IP 04.05.14		CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
96/07/23 BW



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT AMENDMENT
WITH NOTICE
VENDOR ORDER
NO. 22027

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No	: 0022027	Department Code:	
Project Name	: D2581	Burden Flags	: NNNNNNNN
Project For	: WK452	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2581	Invoice Number	:
Description	: Mounting Bracket	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 52	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 12-03-04		
Est Finish Date	: 12-21-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

		Estimated	Actual
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00

14. MAR. 2002 14:06

ALZ GROTE EXPORT 32 89 301949

NO. 857 P. 7/12

ALZ Handelsvergesellschaft
 Metallgesellschaft
 Geschäftsbereich: Zonen- & Exportvertrieb
 Tel. (089) 30 21 11 - Telefax (089) 30 20 80
 Telex 32053 alzg d
 H.R. Torglerstr. 41, 851 - A.T.W. Nr. 88 401.277.374



Der TÜV Rheinland hat mit Schreiben vom 21.
 März 1992 auf die Gegenzeichnung verzichtet

SURVEYOR'S MARK
 CACHET DE L'EXPORT
 STIMPEL DES WEKESACHVERSTÄNDIGEN



Certificate of test - Mill certificate
Certificat de Réception C.C.P.U.

No 2002.0037314
 Nr

Abnahmeprüfungsbericht
 nach DIN 50042/2.1.8 - NFA 00001/3.1.8 - EN 10204/3.1.8

D2581

Approved as supplier according to
 AG/VO - TND 101 statement W E 603
 certified acc. Pressure Equipment
 Directive (92/22/EEC) by TÜV

PROD. PROC.: Electric Arc Furnace - VOD - Continuous Casting
 PROC. FABRIC: Four 8 Ans - VOD - Continuous
 FERTIGUNGSABF.: Elektro-Lichtbogen Ofen - VOD - Strangguss

Voor order n° - votre n° de com - Bestell.Nr

0020007207
 SP796

our order n° - votre n° de com - Werkstoff

47912/329/03

STAINLESS STEEL, COILS, COLD ROLLED, FINISH 2 B

Heat n° - n° coque
 Schmelze Nr
 K 136018

Roll n° - n° bobine
 Band Nr
 13601820

Specifications - Spécifications - Vorschriften

Type - Niveau - Qualität

Finish

Corrosion test - Corr. Inter - Int. Inter. Corr.

ASTM A240/A 240M-01
 ASME SA 240-01

TYPE 304 - S 30400
 TYPE 304 - S 30400

2B
 2B

ASTM A262 E - 01 :OK

Dimensions - Abmessungen

mm 3.04 1219.20
 inches 0.1200 48.000

0.0
 0.00

Material (Code Designation)
 Matière
 Werkstoff
 Bezeichnung
 UNS S 30400

Conditioning
 Hypertemps
 Abschreckung

ASTM A240
 1050°C

temper at
 air treated
 beheizter Luft

Particulars - Particulars - Sonderanforderungen:

AMS 5513-G98 -- ASTM A276/00-A+A312/A312M-01 (CHEM. COMP.) + A666/00
 - MATERIAL MERCURY FREE - NO WELD REPAIRING

CHEMICAL ANALYSIS
 COMPOSITION CHIMIQUE
 CHEMISCHE ZUSAMMENSETZUNG

ELEMENTS	LAZIE ACIERIE SCHMELZE	PRODUCT PRODUIT STÜCKHAAL
C	0.042	0.044
Mn	1.31	1.32
P	0.029	0.030
S	0.004	0.003
Si	0.48	0.48
Cr	18.20	18.22
Ni	8.14	8.12
Mo		
Cu		
Ti		
Co		
N	0.057	0.056
Al		

MECHANICAL PROPERTIES - PROPRIÉTÉS MEC. - MECH. WERTE

TENSILE TEST
 ESSAI DE TRACTION
 ZUG VERSUCH

ROOM TEMP. - TEMP. AMBI. - RAUMTEMP.

OBTAINED - OBTENU - ERGEBNISSE

TEMP.

REQ. - DOCC
 ANFORDERG.

OBTAIN. - OBTENU
 ERGEBNISSE

ASTM

RS

TEST N° - NO TEST - PRÜFST

min.

min.

A240

min. max.

A (T) E

min.

min.

Acoustic Emission

min. max.

12.46X 2.86

min.

min.

Yield

0.2%

30

min.

min.

Ultimate

1.0%

49.8 49.0

min.

min.

Str. strength

1.0%

54.1 52.8

min.

min.

Yield strength

75

98.8 97.6

min.

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Yield strength

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